

Date: Thursday, 6/15/2006 1:41:25 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LOCK PLATE
 Job Number : 27556A
 Estimate Number : 10332
 P.O. Number : N/A Part Number : D2534
 This Issue : 6/15/2006 S.O. No. : N/A Drawing Number : D2534 REV D
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : D
 Previous Run : 26406A Material : N/A
 Written By : SCA COMMENT Below Due Date : 6/30/2006 Qty: 51 Um: Each
 Checked & Approved By : HA 06.06.15
 Comment : Est Rev: A New Issue 05-11-07 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Order (2) D2534 per (1) D2530

Issue P/O:

Email or ship DXF file to vendor

Laser cut D2534 flat pattern per Dwg D2534

Material release note required

MATERIAL: 304 SS .125" THK.
 (M304S116A)

(.045 SF)

Batch: M6789

M6789

2.0 ~~D2534F~~ Lock Plate



Comment: Qty: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

Lock Plate

Deburr

M.F. 06/06/30

SAD 06:06:22

51

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

N/A

4.0 QCB 2 DIMENSIONAL CHECK



Comment: Inspect dimensions per template D2534-T1

SAD

06:06:22

51

5.0 SMALL FAB T QCB SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

M.F. 06/06/30

51

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *DS* Date: 06/08/03

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 6/15/2006 1:41:25 PM
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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

M 06/07/26 (57)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/08/03 (51)

Job Completion



C 206/08/03

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |



| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

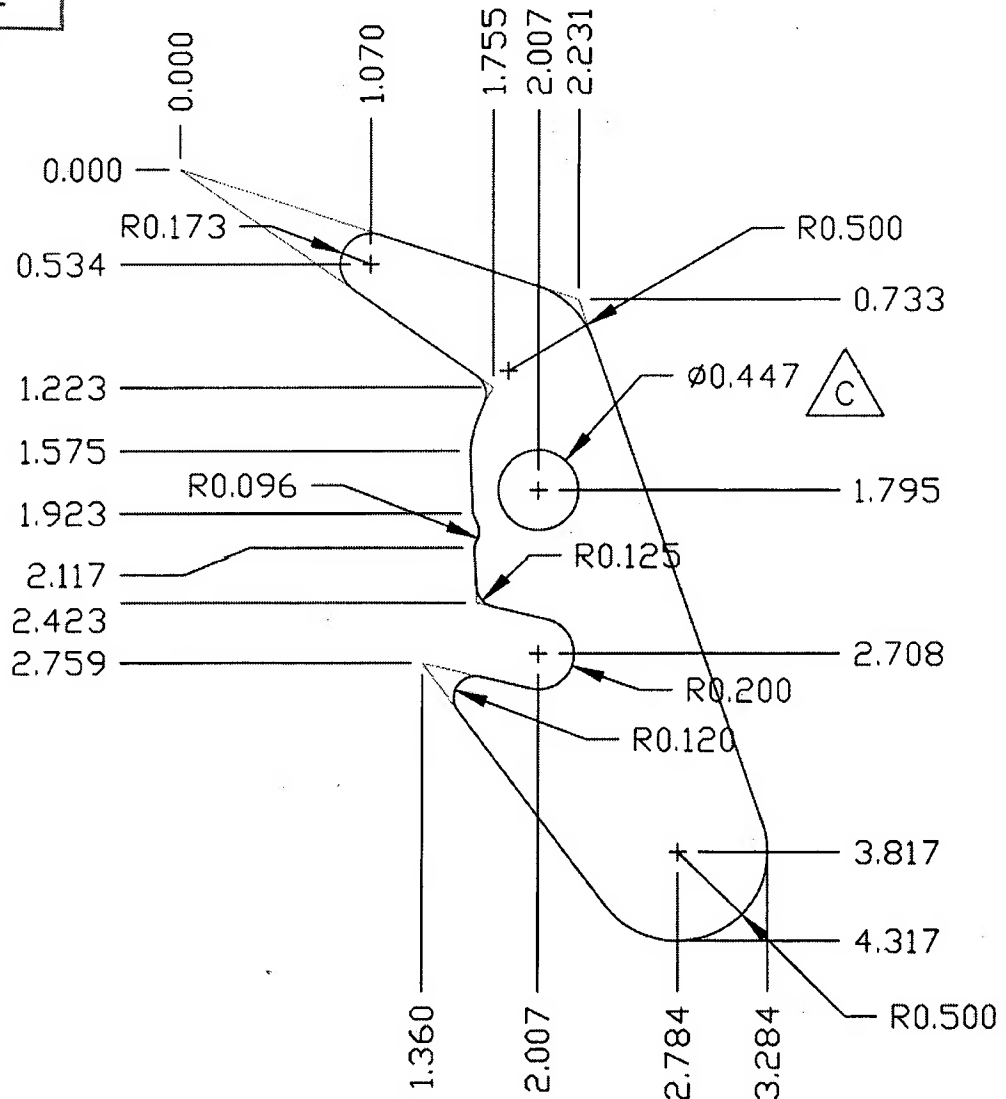

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

| | | | |
|---|--|--|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD | |
| B WILLIAMS | PH | VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED  | APPROVED  | DRAWING NO. | REV. D |
| | | D2534 | SHEET 1 OF 1 |
| DATE | | TITLE | SCALE |
| 04.12.14 | | LOCK PLATE | 1:1 |
| C | 96.07.26 | HOLE WAS 0.328 | |
| D | 04.12.14 | UPDATE NOTES | |

RELEASED04.12.16 **D2534 LOCK PLATE**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 11 GAUGE (0.125 THICK) (REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27556A

Date: Wednesday, 6/21/2006 9:15:56 AM
 User: Linda Lacelle

Process Sheet

| | |
|---|-------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : LOCK PLATE |
| Job Number : 27556A | |
| Estimate Number : 10332 | |
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| Prsht Rev. : NC | Project Number : N/A |
| First Issue : 6/15/2006 Type : SMALL /MED FAB | Drawing Revision : D |
| Previous Run : 26406A | Material : N/A |
| Written By : <u>SEE COMMENT BELOW</u> | Due Date : 6/30/2006 |
| Checked & Approved By : _____ | Qty: 40 Um: Each |
| Comment : Est Rev:A New Issue 05-11-07 JLM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------|--------------------|
| 1.0 | M304S16GA | 304/316 .063 Sheet |
|-----|-----------|--------------------|



Comment: Qty.: 0.0450 sf(s)/Unit Total : 1.8000 sf(s)
 304/316 .063 Sheet

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: Inspect dimensions per template D2534-T1

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

| | | |
|-----|-------------|-----------------------|
| 6.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

Date: Wednesday, 6/21/2006 9:15:56 AM
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Job Number: 27556A

Part Number: D2534

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

